Date:

Tuesday, 7/1/2008 11:36:55 AM

User:

Kim Johnston

**Process Sheet** 

**Drawing Name** 

Part Number

**Drawing Number** 

Project Number

Customer Job Number

: CU-DAR001 Dart Helicopters Services

: 40152 : 10165

**Estimate Number** 

P.O. Number

: 7/1/2008 This Issue

: NC Prsht Rev.

First Issue : 34521 Previous Run

: 7/1/2008

S.O. No. :

: MACHINED PARTS Type

**Drawing Revision Material** 

**Due Date** 

: 7/22/2008

: SPACER

: D25255

: N/A

: B

· D2525 REV B

Qty:

80 Um:

Each

Written By Checked & Approved By

Comment

С

02.08.22

Make in Cobra KJ/RF

**Additional Product** 

Job Number:



Seq. #:

ž

1.0

**Machine Or Operation:** 

M6061T6R0750

Description:

6061-T6 Round Bar .750"

Comment: Qty.:

0.0218 f(s)/Unit

Total:

1.7472 f(s)

6061-T6 Round Bar .750

Make as per Dwg D2525 and Folio FA261.

Material: 5052-H32 (QQ-A-225/7) or 1100 (QQ-A-225/1) or 6061-T6 (QQ-A-225/8) or 6061-T6 (QQ-A-200/8)

Ø0.75 Rod(M5052H32R0.750) or (M6061T6R0.750)

Batch <u>(11038</u>57

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn Blank as per Dwg D2525

2-Deburr

3.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

QC8

SECOND CHECK



Comment: SECOND CHECK





HAND FINISHING1



5.0

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



## **Dart Aerospace Ltd**

W/O:		WORK ORDER (	CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·					:	
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
		•	QA: I	N/C Close	d:	_ Date: _	
	<u> </u>	WORK ODDED NON COM	EODMANCE /NO	2/			

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					FORMANCE (NCR)	
		Description of NC		Corrective Action Section B		Verification	Annroval	Anneoval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
				•					
	1								

NOTE: Date & initial all entries

Tuesday, 7/1/2008 11:36:55 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services

Job Number:



Seq. #: **Machine Or Operation:** 

6.0 QC3

Job Number: 40152

Description:

INSPECT POWDER COAT/CHEMICAL CONVERSION

Part Number: D25255

Comment: INSPECT ALODINE

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

8.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 58 07.08

Dart Ae	rospace	Ltd						
W/O:			WC	ORK ORDER CHANGE	S			······································
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector
				The second section is a second section of the section o				
							<b> </b>	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:_	Date: _	
					QA: N	C Closed: _	Date: _	
NCR:			NORK ORDI	ER NON-CONFORMA	NCE (NCR	)		
		Description of NC		Corrective Action Section	ı B	Verification	on Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
•						į		
						***		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40152
Description: Spacer	Part Number:	D2525-5
Inspection Dwg: D2525 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0/92	J,			
Ø0.750	+0.008/-0.001	\$ .750	1			
Ø0.515	+0.008/-0.001	517	V			
	:					
		<del></del>			,,, <u></u>	

Measured by:	MM	1021	Audited by:	H.A.	Prototype Approval:	N/A	
Date:	Ca (872)	95	Date:	08/07/05	Date:	" N/A	

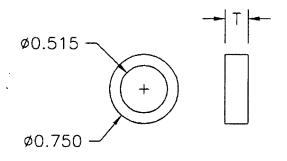
Rev	Date	Change	Revised by	Approved
Α	06.07.05	New Issue	KJ/JLM	



DESIG	BW	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D .
CHEC	KED	APPROYED	DRAWING NO.	REV. B
	HE	T	D2525 sh	HEET 1 OF 1
DATE			TITLE	SCALE
99.0	09.30		SPACER KIT	1:1
Α		95.12.22	NEW ISSUE	
В		99.09.30	REVISED MATERIAL	



PART NUMBER	THICKNESS T	QTY
D2525-1	0.750	1
D2525-3	0.250	1
D2525-5	0.125	4
D2525-7	0.063	0
D2525-9	0.032	0



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MATERIAL: 5052-H32 (QQ-A-225/7) OR 1100 (QQ-A-225/1) OR 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1